

Work Order ID 112878

February-10-14 10:29:10 AM

112878

Page 1

Item ID: 646.3301 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Upper Cutter Assy
 Start Date: 2/12/14 Start Qty: 2.00 ~~*2*~~ 3 Cust Item ID:
 Required Date: 2/12/14 Req'd Qty: 2.00 ~~*2*~~ 3 Customer:
 Reference:

Approvals: Process Plan: MLS Date: 14-02-10 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
646.3300	N/C								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120		0.00							
120									
Small Fab	Memo	0.00							
Small Fab	Two fastener must be install finger-tight (see note 9)								
	Assemble as per dwg and apply loctite 598 on all faying surfaces shown on dwg per note 7.								
	A/R RTV LOCTITE 598: <u>127443</u>								
	exp. date: <u>10/15</u>								

N/A MLS 14-06-03

3 0 0 AP
14-6-2

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Page 2

Item ID: 646.3301 Accept ***N900040100*** Setup Start ***NS1***
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 Item Name: Upper Cutter Assy
 Start Date: 2/12/14 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 2/12/14 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC5- Inspect part completeness to step on W/O	0.00							
130									
QC	Memo	0.00							
Quality Control									
140	Identify as per dwg & Stock Location: _____	0.00							
140									
Packaging	Memo	0.00							
Packaging	***IDENTIFY AS PER APICAL MPP-120 BY STAMPING THE P# AND REV***								
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.00							
Quality Control									

JUN 02 2014

~~JUN 20 2014~~

14-06-03

Picklist Print

February-10-14 10:29:09 AM

Page 1

Work Order ID: 112878
Parent Item: 646.3301
Parent Item Name: Upper Cutter Assy

Start Date: 2/12/14
Start Qty: 2.00

Required Date: 2/12/14
Required Qty: 2.00

Comments: IPP REV:A 12.10.19 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
646.3310 LH Half		Manufactured	No			110	Each	20.0000	1	2		AS 14-6-2	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				CA		20							
				101038		4			(3) #2				
				108495		4							
				109916		12							
646.3311 RH Half		Manufactured	No			110	Each	27.0000	1	2		AS 14-6-2	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				CA		27							
				100844		10			(3) #2				
				102840		8							
				107606		2							
				108423		7							
646.3312 Center Plate		Manufactured	No			110	Each	21.0000	1	2		AS 14-6-2	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				CA		21							
				103083		6							
				103686		6			(3) #2				
				108244		6							
				108526		3							
646.3313 Upper Guide		Manufactured	No			110	Each	9.0000	1	2		AS 14-6-2	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				CA		9			(3)				
				106094		2							
				107622		7							
				109917									
				101038									

Picklist Print

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Page 3

Work Order ID: 112878
Parent Item: 646.3301
Parent Item Name: Upper Cutter Assy

Start Date: 2/12/14

Required Date: 2/12/14

Start Qty: 2.00

Required Qty: 2.00

MS21042L08
Nut

Purchased No

110 Each 3,652.0000 18

36

AP 14-6-2

128429
Location

Loc Qty

Loc Code

ST314

58

123900

58

ST508

3400

125445

1900

m127410

1500

ST509

194

m127304

194

(54)

NAS1149F0332P
Washer

Purchased No

110 Each 6,048.0000 6

12

AP 14-6-2

128401
Location

Loc Qty

Loc Code

GA

205

122063

205

ST295

12

123900

12

ST510a

5831

125646

3331

m127831

2500

(18)

AN3-12A
Bolt

Purchased No

110 Each 45.0000 2

4

AP 14-6-2

128687
Location

Loc Qty

Loc Code

ST511

45

m125709

45

(6)

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Shop Packet Print

Page 3

Picklist Print

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Page 4

Work Order ID: 112878
 Parent Item: 646.3301
 Parent Item Name: Upper Cutter Assy

Start Date: 2/12/14

Required Date: 2/12/14

Start Qty: 2.00

Required Qty: 2.00

MS21042L3 Purchased No 110 Each 4,419.0000 3 6 AR 14-6-2

Nut

128754

Location	Loc Qty	Loc Code
ST314	464	
M127304	423	
M127831	41	
ST506	955	
123900	955	
ST509	3000	
M127410	3000	

MS27039-08-19

Screw

Purchased No

110 Each 2,793.0000

18 36

AR 14-6-2

Location	Loc Qty	Loc Code
ST506	2793	
<u>124309</u>	1171	
125654	127	
m127410	400	
m127831	95	
m127904	1000	

AN3-14A

Bolt

Purchased No

110 Each 165.0000

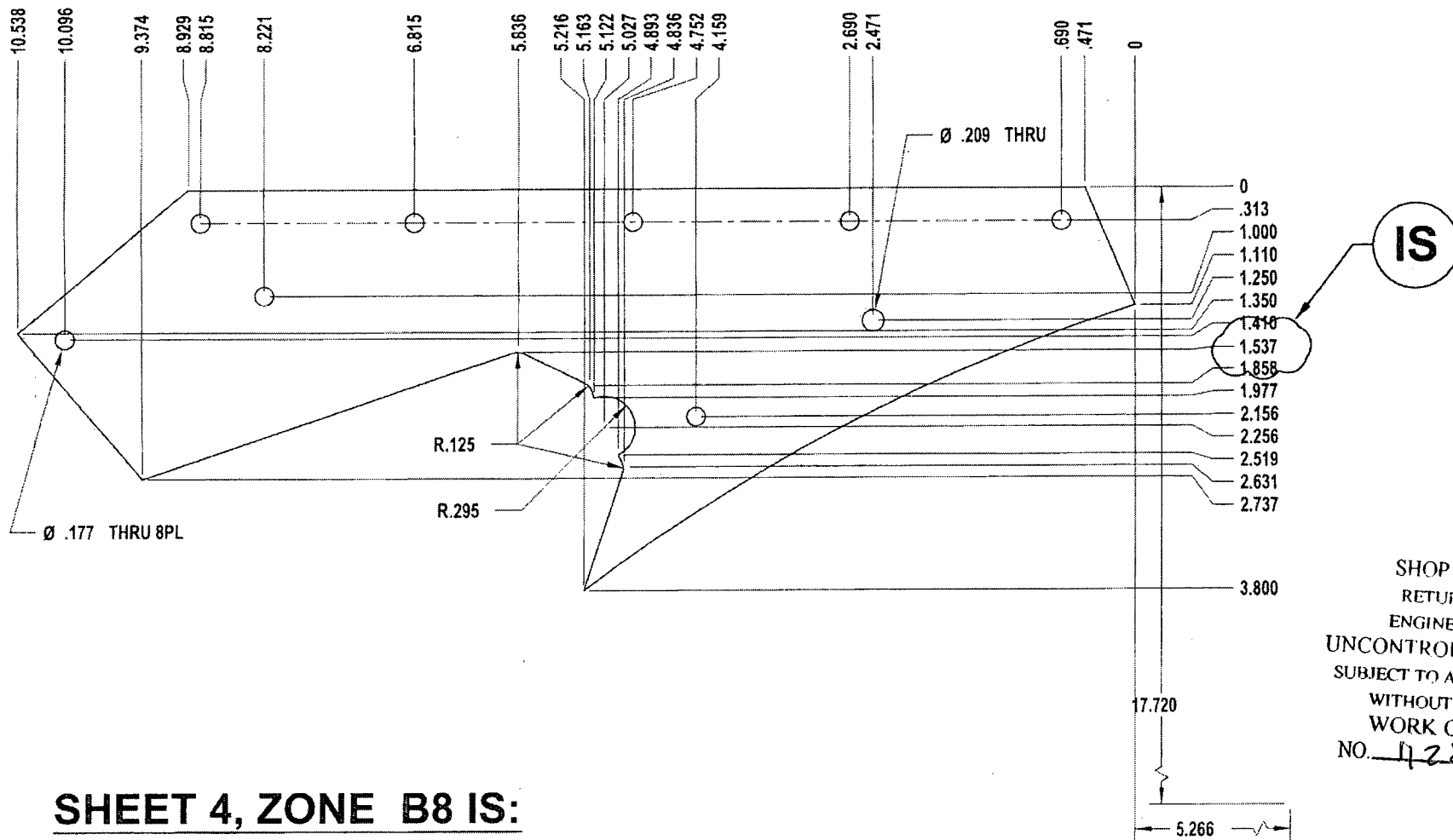
1 2

AR 14-6-2

128978

Location	Loc Qty	Loc Code
ST351	90	
m127044	90	
ST511	75	
m127815	75	

APICAL INDUSTRIES, INC.	ENGINEERING CHANGE NOTICE NO. 03724				SHEET 1 OF 1	
	DWG NO. 646.3300	REV: N/C	PREPARED BY B. PETERS	DATE: 12/05/12	EFFECT ON DWG <input type="checkbox"/> INC. <input checked="" type="checkbox"/> UNINC.	
	DWG TITLE: UPPER CUTTER ASSY					
	APPROVED BY: ENGR <i>[Signature]</i>	MFG <i>[Signature]</i>	QC <i>[Signature]</i>	EFF: NEXT ORDER		
TRANSACTION CODES (TC) A-ADD C-CREATE R-REVISE D-DELETE	REASON: REVISED ORDINATE DIMENSION.				ECR: D-12-025	



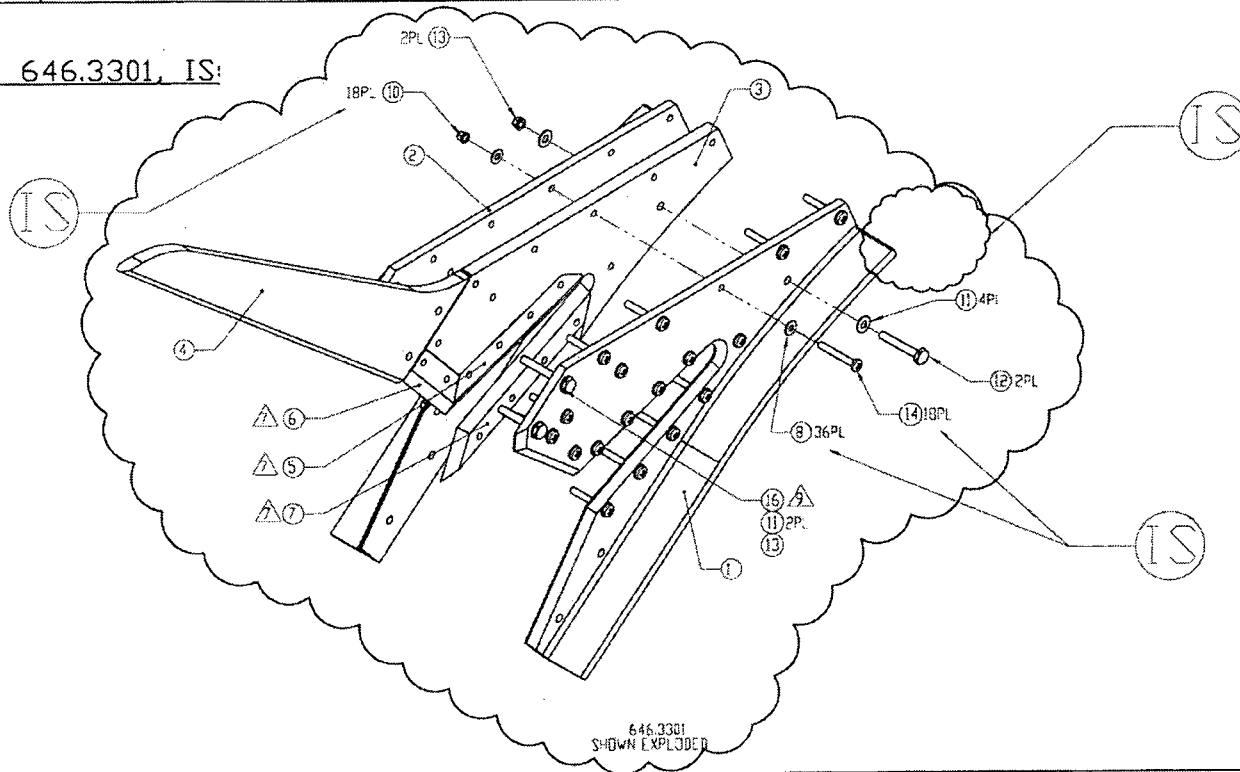
SHEET 4, ZONE B8 IS:

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 142878 MWS
1402-W

DOCUMENTS EFFECTED:	<input type="checkbox"/> RFMS <input type="checkbox"/> MDL <input type="checkbox"/> INSTALL INSTRU <input type="checkbox"/> ICA <input type="checkbox"/> BOM	CHANGE CATEGORY <input type="checkbox"/> MAJOR <input checked="" type="checkbox"/> MINOR	DER REVIEW REQUIRED <input type="checkbox"/> YES <input checked="" type="checkbox"/> NO
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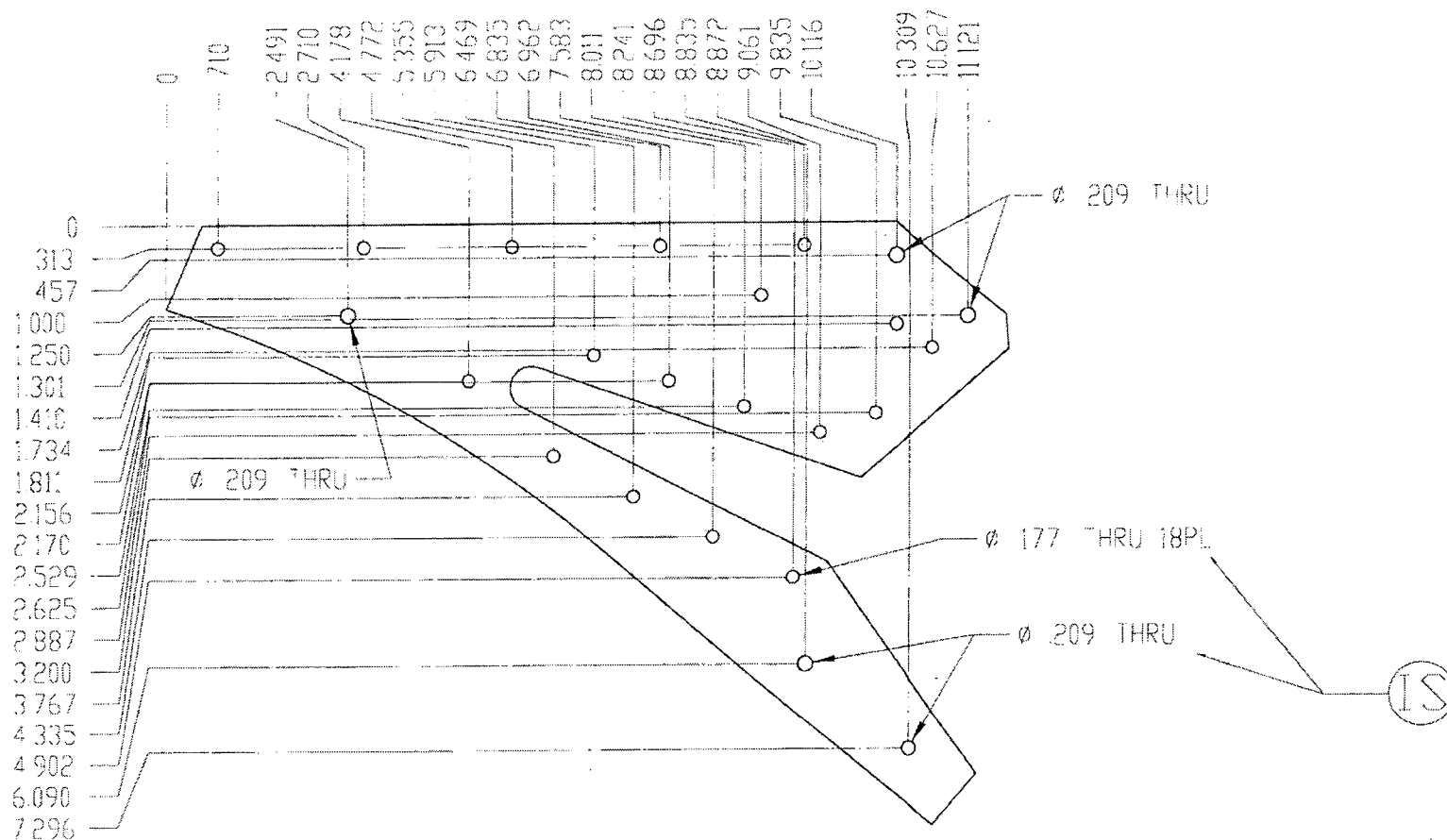
APICAL INDUSTRIES, INC.	ENGINEERING CHANGE NOTICE NO. 02196				SHEET 1 OF 2	
	DWG NO. 646.3300	REV: N/C	PREPARED BY S. HUFF	DATE: 01/05/09	EFFECT ON DWG: <input type="checkbox"/> INC. <input checked="" type="checkbox"/> UNINC.	
	DWG TITLE: UPPER CUTTER ASSY					
	APPROVED BY: ENGR <i>[Signature]</i>	MFG <i>[Signature]</i>	QC <i>[Signature]</i>	EFF: NEXT ORDER		
TRANSACTION CODES (TC): A-ADD C-CREATE R-REVISE D-DELETE		REASON: REMOVED RIVETS IN FAVOR OF ADDITIONAL SCREWS				

SHEET 1, VIEW 646.3301, IS:



14	R	601.2765	18	SCREW	MS27039-0819
10	R	601.1541	18	LOCKNUT	MS21042L08
9	D	601.2766	3	RIVET	MS20470AD5-18
8	R	601.2764	36	WASHER	NAS1149FN832P
			.3301		
F/N	TC	PART NUMBER	QTY	DESCRIPTION	MATERIAL/SPECIFICATION
DOCUMENTS EFFECTED:					CHANGE CATEGORY
<input type="checkbox"/> MDL <input checked="" type="checkbox"/> INSTALL INSTRU <input checked="" type="checkbox"/> ICA <input type="checkbox"/> FMS <input checked="" type="checkbox"/> BOM					DER REVIEW REQUIRED
					<input type="checkbox"/> MAJOR <input checked="" type="checkbox"/> MINOR
					<input type="checkbox"/> YES <input checked="" type="checkbox"/> NO

SHEET 3, SECTION VIEW A-A, IS:



SECTION A-A

F/N	TC	PART NUMBER	QTY	DESCRIPTION	MATERIAL/SPECIFICATION
-----	----	-------------	-----	-------------	------------------------

714	EXPLOSION	DATE	APPROVED
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02196, 03724

① MATERIAL: ALUMINUM 7075-T651 PER AMS-QQ-A-250/12

② FINISH: HARD ANODIZE 1AW MIL-A-8625 TYPE III;
CLASS 2, COLOR BLACK;
CARDINAL 4860-50 PRETREATMENT PRIMER
PRIME 1AW MIL-P-23377 J TYPE I CLASS N

③ MATERIAL: AISI A2 TOOL STEEL
CONDITION: ANNEALED
POST PROCESS: HEAT TREAT TO 58-62 Rc ROCKWELL HARDNESS

④ FINISH: PRIME 1AW MIL-P-23377 J TYPE I CLASS N

6. IDENTIFY LAW MPP-120

7. APPLY F/N 15 AS REQUIRED TO ALL FAYING SURFACES OF F/N 5, 6 & 7 UPON ASSEMBLY.

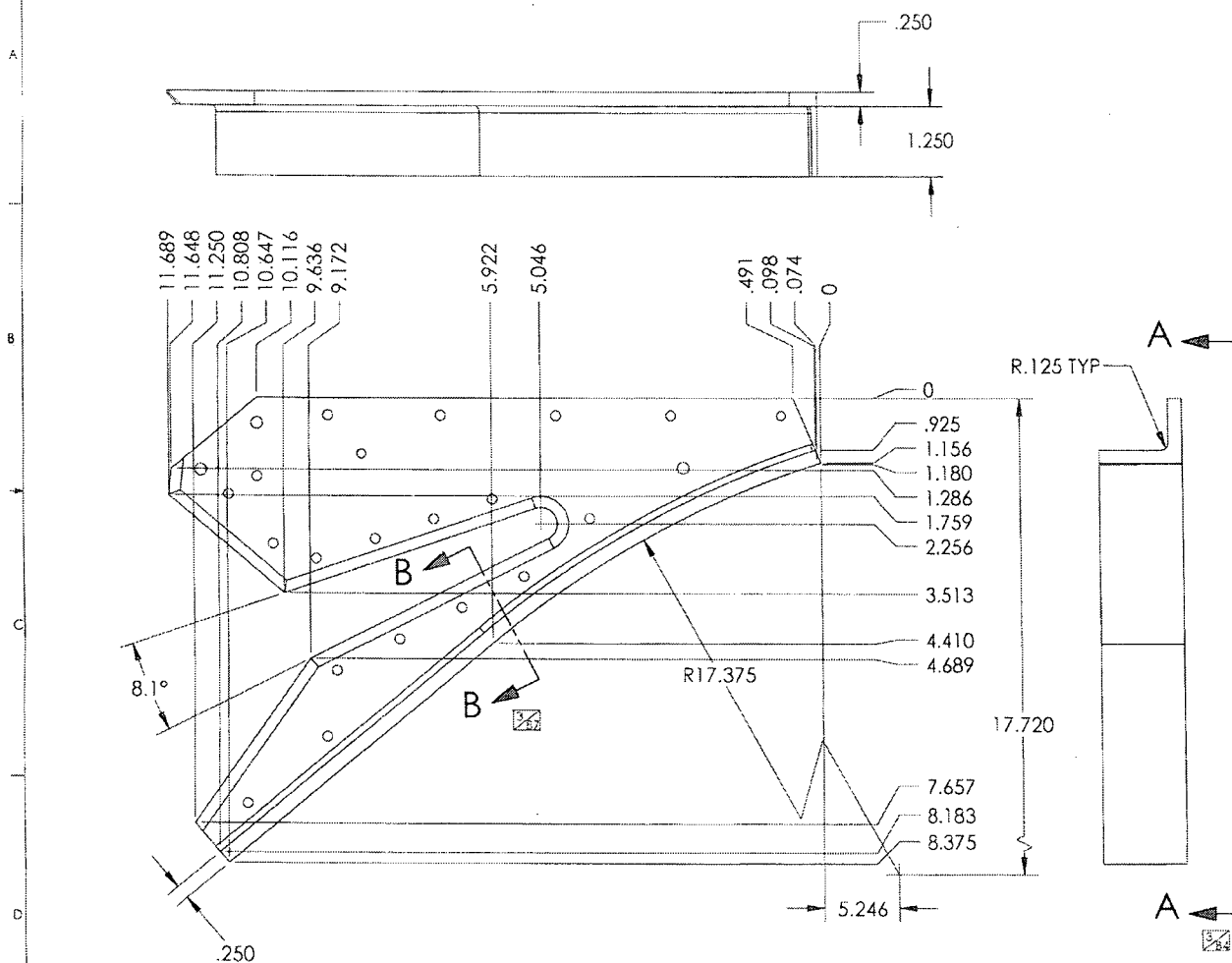
8 CUTTING EDGE INTENDED TO BE SHARP, DO NOT BREAK SHARP EDGE

9 INSTALL FASTENER FINGER-TIGHT

646.3301
SHOWN EXPLODED

[illegible]

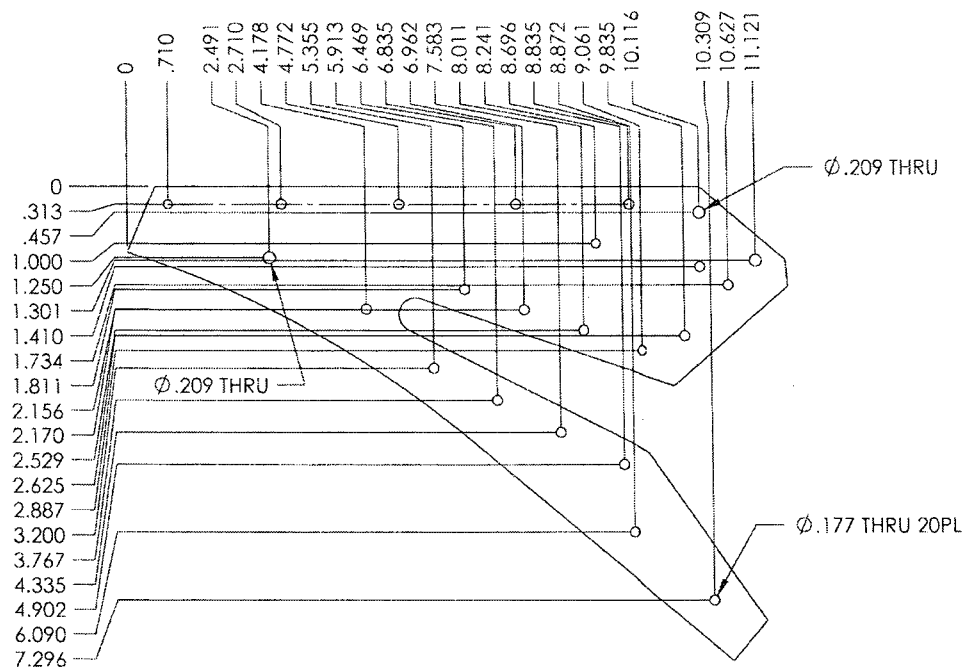
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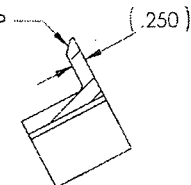
646.3310 SHOWN
646.3311 OPPOSITE

APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-0300	
UPPER CUTTER ASSY	
DATE: 07/16 DRAWN BY: 646.3300 CHECKED BY: N/C	SCALE: NONE SHEET: 2 OF 2

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.200 X 45.0° TYP



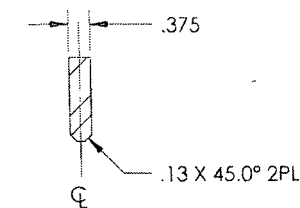
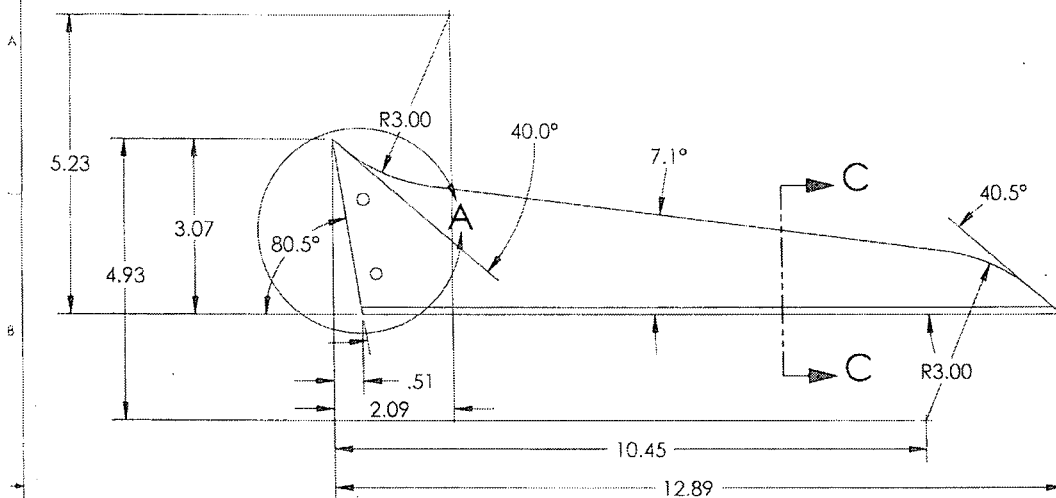
SECTION B-B

SECTION A-A

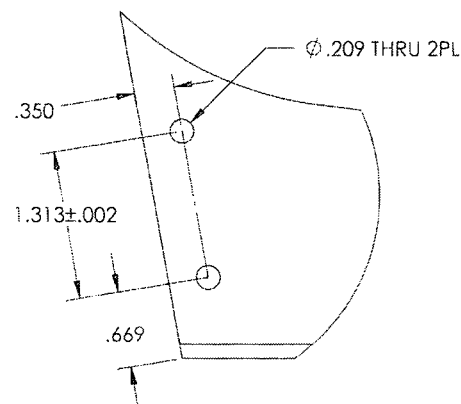
ORIGINAL DATE AND SHEET		APICAL INDUSTRIES	
DRAWN BY		2608 TEMPLE HEIGHTS DR.	
CHECKED BY		OCEANSIDE, CA. 92054-3512 (760) 724-5300	
DRAWING APPROVAL		UPPER CUTTER ASSY	
REVISIONS		SCALE NONE	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: FRACTIONS DECIMALS ANGLES		128 0-01000 128 128	REV N/C
5 07/12/26		646.3300	SHEET 3 OF 6

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REVISION			
REV	DESCRIPTION	DATE	APPROVED



SECTION C-C



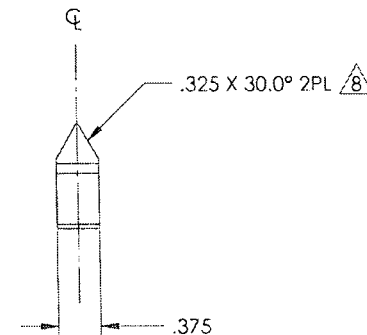
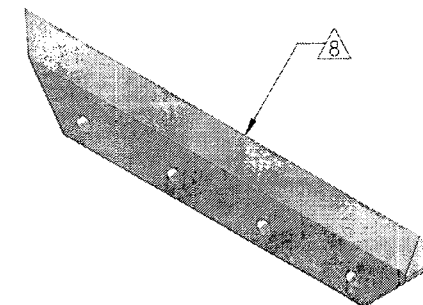
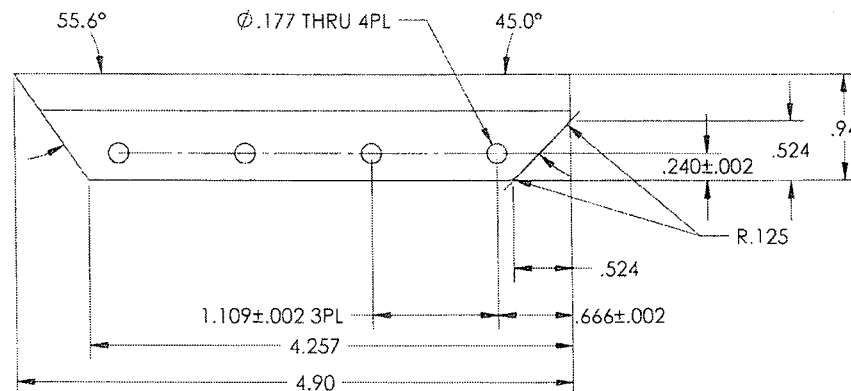
DETAIL A

646.3313

ORIGINAL DATE 12-20-88 DESIGNED BY D. H. H. P. DRAWING APPROVAL D. H. H. P. CHECKED BY D. H. H. P.	APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760) 724-5300
REVISED DIMENSIONS SPECIFIED QUANTITIES IN PARENTHESIS DIMENSIONS IN INCHES DIMENSIONS IN MILLIMETERS DIMENSIONS IN FEET DIMENSIONS IN METERS	SCALE: NONE
PART NAME 646.3300	SHEET 5 OF 8

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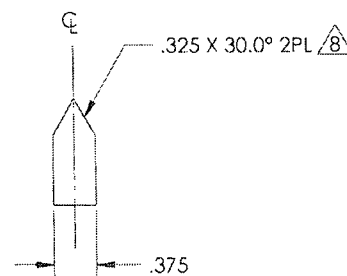
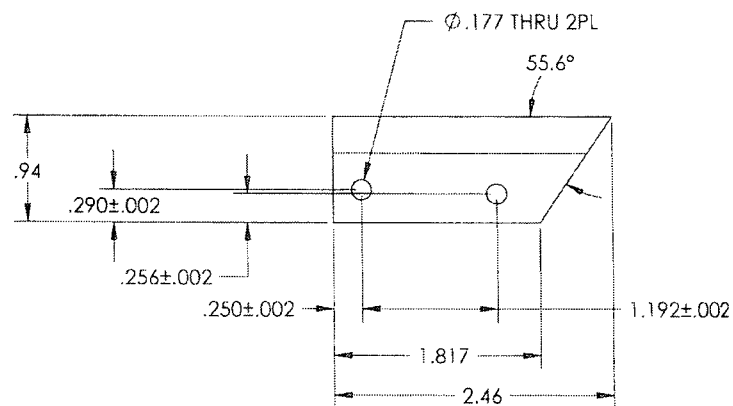
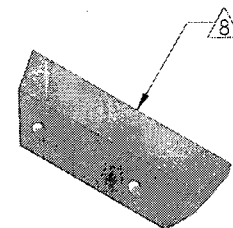
REV	DESCRIPTION	DATE	APPROVED



646.3314

ORIGINAL DATE 10/22/04 DRAWN BY S. HUFF DESIGNED BY S. HUFF CHECKED BY S. HUFF APPROVED BY S. HUFF	APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760) 724-5300 UPPER CUTTER ASSY 646.3300 SCALE 1:1 SHEET 6 OF 8
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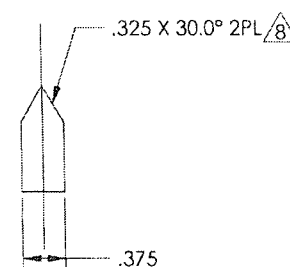
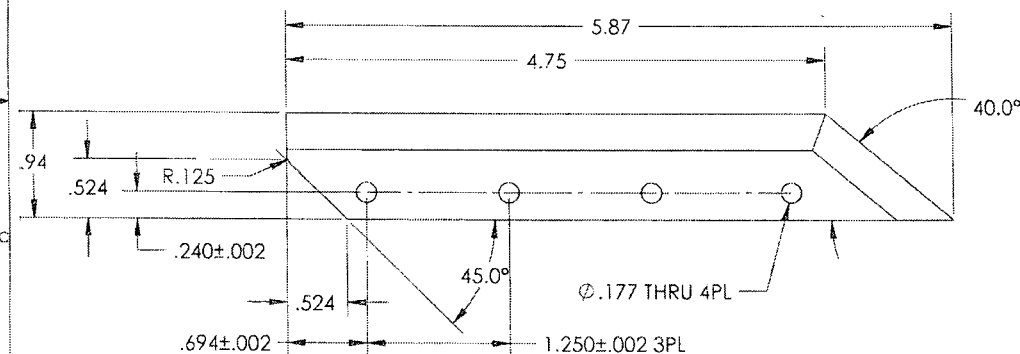
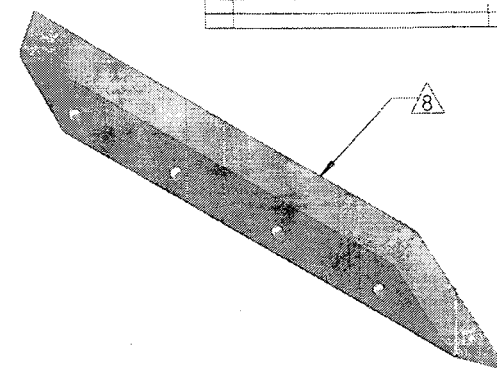
REV		APPROVED	
		DATE	APPROVED



ORDER DATE 05/05/2011 09:26:55 ORDER BY S. WARR QUANTITY 1 UNIT EA COMMENTS 10	APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA 92056-3512 (760) 724-5300 UPPER CUTTER ASSY
PART NUMBER 646.3300 DESCRIPTION UPPER CUTTER ASSY QUANTITY 1 UNIT EA	KIT 646.3300 SCALE NONE SHEET 2 OF 2

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REV	REVISION	DATE	APPROVED



646.3316

ORIGINAL DATE 1/20/10 DRAWN BY S. HUNT CHECKED BY S. HUNT DRAWING APPROVAL S. HUNT CONTRACT NO.	APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92054-3512 (760)724-5300 UPPER CUTTER ASSY
1. 10.00 CHANGES REQUIRED 2. 10.00 CHANGES REQUIRED 3. 10.00 CHANGES REQUIRED 4. 10.00 CHANGES REQUIRED 5. 10.00 CHANGES REQUIRED 6. 10.00 CHANGES REQUIRED 7. 10.00 CHANGES REQUIRED 8. 10.00 CHANGES REQUIRED 9. 10.00 CHANGES REQUIRED 10. 10.00 CHANGES REQUIRED	SHEET 8 OF 8 SCALE NONE 646.3300 N/C